

D8731

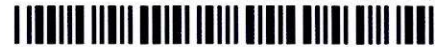


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2665-2

Job Sheet 208465



Part No: D2665-2

Job Qty: 6 pcs

Part Name: Saddle, RH, Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	4/13/20		1.00	12.96	HAAS - 1		
							HAAS - 2		
							HAAS - 3		DJP 20-04-14
							HAAS - 4		
110	Conventional Mill - 1 - B4B	6 pcs	4/13/20		0.00	0.64	Conventional Mill - 1 - B4B		DJP 20-04-14
							Conventional Mill - 2 - B4B		
120	QC 2	6 pcs	4/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S270004



Part: D2665-2

Job No: 208465

Serial No/Batch: S270004

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/12/20

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
130 QC 8	6	4/13/20	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
140 Handfinish - 1-1 Chemical-B4B	6	4/13/20	0.00 0.47	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	

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						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	6 pcs	4/13/20	0.00	0.28	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
160	QC 3	6 pcs	4/13/20	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
170	Packaging 3-1 - Stock - B4B	6 pcs	4/13/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Plex 3/20/20 10:13 AM Dart.lajeunesse.marie	

DAS
15
9-89

DAS
28
9-89

					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	6 pcs	4/13/20	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - HAAS CNC Vertical Machine - 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per Descriptions: attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached 110 - Manufacture as per dwg Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6101-003	Saddle Billet, 7075	6 pcs (1 ea)	100-HAAS 4 Axis	S261891	x6	
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-HAAS 4 Axis	D6101-003	6	36	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order: 208465
Description: 206 Saddle, Outboard, Right side		Part Number: D2665-2
Inspection Dwg: D2665 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	0.1185	0.118	0.118	0.118
B	0.100	0.140		.116	0.123	0.122	0.122	0.122
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		.675	0.680	0.680	0.680	0.680
E	0.240	0.260		.253	0.251	0.251	0.251	0.251
F	1.313	1.343		1.326	1.326	1.326	1.326	1.326
G	0.210	0.230		.226	0.224	0.224	0.224	0.224
H	0.100	0.180		.135	0.130	0.130	0.130	0.130
I	2.470	2.510		2.492	2.492	2.492	2.492	2.492
J	1.565	1.585		1.573	1.575	1.575	1.575	1.575
K	0.235	0.240		0.2375	0.2375	0.2375	0.238	0.238
L	0.100	0.120		0.110	0.110	0.110	0.110	0.110
M	0.990	1.010		1.004	1.004	1.004	1.004	1.004
N	0.510	0.515		0.511	0.511	0.511	0.511	0.511
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		0.313	0.313	0.313	0.313	0.313
S	0.315	0.322		.316	0.316	0.316	0.316	0.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.796	0.795	0.795	0.794	0.7945
W	0.540	0.560		.547	0.550	0.547	0.547	0.548
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.257	0.258	0.258	0.258	0.258
Z	0.912	0.932		.923	0.924	0.924	0.925	0.924
AA	0.490	0.510		0.501	0.501	0.499	0.500	0.500
AB	0.178	0.198		.188	0.188	0.188	0.188	0.188
AC								
AD								
AE								
Accept/Reject								

Measured by: [Signature]	Date: 20-04-14
Audited by: [Signature]	Date: 20/04/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	[Signature]

DART AEROSPACE LTD				Work Order: 208465	
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Inspection Dwg: D2665 Rev: D DSK: Rev:				Page 1 of 1	

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B	0.100	0.140		0.122				
C	1.125	1.145		1.135				
D	0.615	0.685		0.680				
E	0.240	0.260		0.251				
F	1.313	1.343		1.326				
G	0.210	0.230		0.2235				
H	0.100	0.180		0.130				
I	2.470	2.510		2.492				
J	1.565	1.585		1.575				
K	0.235	0.240		0.238				
L	0.100	0.120		0.110				
M	0.990	1.010		1.004				
N	0.510	0.515		0.511				
O	5.990	6.010		6.000				
P	1.245	1.255		1.250				
Q	2.495	2.505		2.500				
R	0.312	0.318		0.313				
S	0.315	0.322		0.316				
T	2.495	2.505		2.500				
U	1.357	1.367		1.362				
V	0.787	0.807		0.794				
W	0.540	0.560		0.549				
X	1.674	1.684		1.679				
Y	0.256	0.262		0.258				
Z	0.912	0.932		0.924				
AA	0.490	0.510		0.500				
AB	0.178	0.198		0.188				
AC								
AD								
AE								
Accept/Reject								

Measured by: JTP	Date: 20-04-14
Audited by: [Signature]	Date: 20/04/17
Prototype Approval:	Date:

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A		New Issue	RF	
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F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					